



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2012-115-3
Job Sheet 176111



Part No: D2012-115-3

Job Qty: 5 ea

DAS
21
9-89

Part Name: Joggled Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/17/18

Job Tracking No:

Due Date: 5/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 12.05.29 MADE IN HOUSE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		5/10/18	0.00	0.00	Start Up Waterjet		OK 18/04/23
100	Waterjet	5 pcs		5/10/18	0.00	0.28	Waterjet1		OK 18/04/23
110	QC	5 pcs		5/10/18	0.00	0.00	QC2 Waterjet-4		OK 18/04/23
120	QC	5 pcs		5/10/18	0.00	0.00	QC8		38
130	Brake NC	5 pcs		5/11/18	0.10	0.31	Brake NC 1		1.89 DAS
140	QC	5 pcs		5/11/18	0.00	0.00	QC5		FEB 06 2019 68
150	Packaging	5 pcs		5/11/18	0.00	0.00	Packaging3		FEB 06 2019 9-89
160	QC21-SA	5 Ea		5/11/18	0.00	0.00	QC21		FEB 06 2019

Part Op Descriptions: 100 - 1-Cut as per Dwg Dwg Rev: Prog Rev: 2-Deburr if necessary

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.0800 sf (.016 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	0	149	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Joggled Bracket	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Joggled Bracket	0.010 Inches	Min		
3	Joggled Bracket	0.010 Inches	Min		
4	Joggled Bracket	0.030 Inches	Min		
5	Joggled Bracket	0.010 Inches	Min		
6	Joggled Bracket	0.030 Inches	Min		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Rejected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date : _____		QTV Effective : _____		MRB (QSI042) Approval																																																																															
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							